

Date: Tuesday, 30/01/2007 10:56:53 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 30206	
Estimate Number : 12543	
P.O. Number : <i>N/A</i>	Part Number : D35381
This Issue : 30/01/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3538 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 09/01/2007 Type : MACHINED PARTS	Drawing Revision : REV.A
Previous Run : 28822	Material : <i>N/A</i>
Written By : _____	Due Date : 16/01/2007 Qty: 4 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 06-10.03 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.1995 f(s)/Unit Total: 0.7980 f(s)

6061_T6 Bar 1.25" x 1.25"

Batch: *118742**J.F. / S.F. 07/01/30*

2.0	BAND SAW	BAND SAW
-----	----------	----------

**Comment:** BAND SAW

Cut blanks 1.50" long

J.F. / S.F. 07/01/30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** 1-Machine as per Folio FA651 and Dwg D3538

2-Deburr

S.F. 07/01/30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*S.F. 07/01/30*

5.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK*SA 07.02.02.*

Date: Tuesday, 30/01/2007 10:56:53 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 30206

Part Number: D35381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

EX /

07/02/05

7.0

POWDER COATING

POWDER COATING



M103141



(7X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MA / YL

07/02/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-02-05 (7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07-02-05 (7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(7) 07-02-08

Job Completion



U 07-02-08

Date: Tuesday, 1/9/2007 7:51:03 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET
Job Number : 30206	
Estimate Number : 12543	
P.O. Number :	Part Number : D35381
This Issue : 1/9/2007 S.O. No. :	Drawing Number : D3538 UNDER REV Rev. A <i>E</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : UNDER REVIEW A <i>E</i>
Previous Run : 28822	Material :
Written By :	Due Date : 1/16/2007 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 06-10.03 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"
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Comment: Qty.: 0.1995 f(s)/Unit Total: 0.7980 f(s)

6061_T6 Bar 0.750 x 1.500

Batch: M18742

J.F. 07/01/29

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: 1-Machine as per Folio FA651 and Dwg D3538

2-Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------


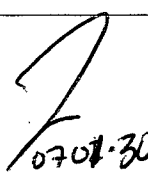
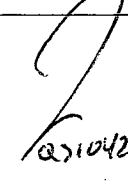
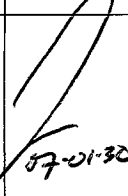


Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/01/30	3.0	one part scrap, erro						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 07/02/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/30	3.0	one part scrap, error in program bottom of material was faced .020" too much.	 QSI042	scrap part and replace program fix	SE 07/01/30	 0701-30	 QSI042	 07-01-30

NOTE: Date & initial all entries

Date: Tuesday, 1/9/2007 7:51:03 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 30206

Part Number: D35381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

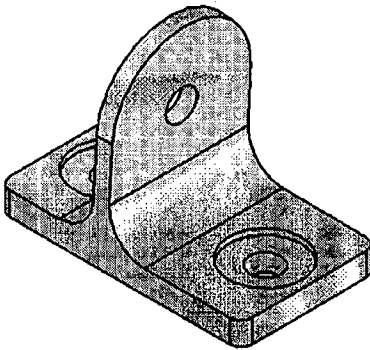
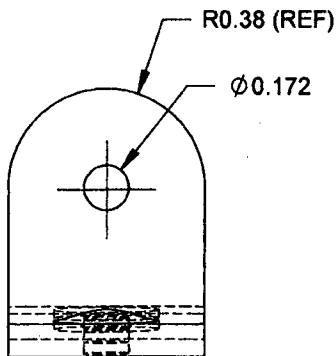
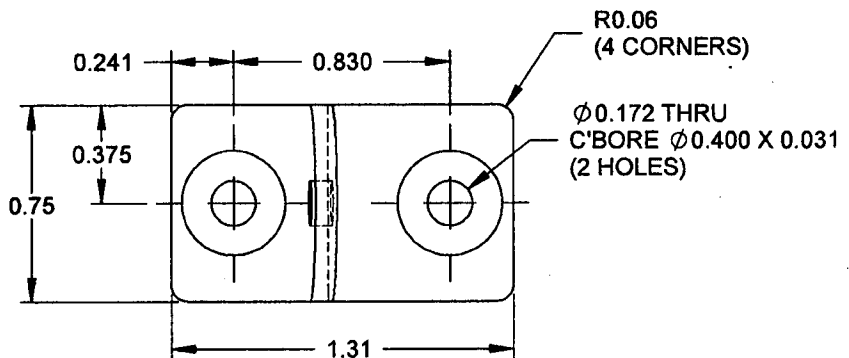
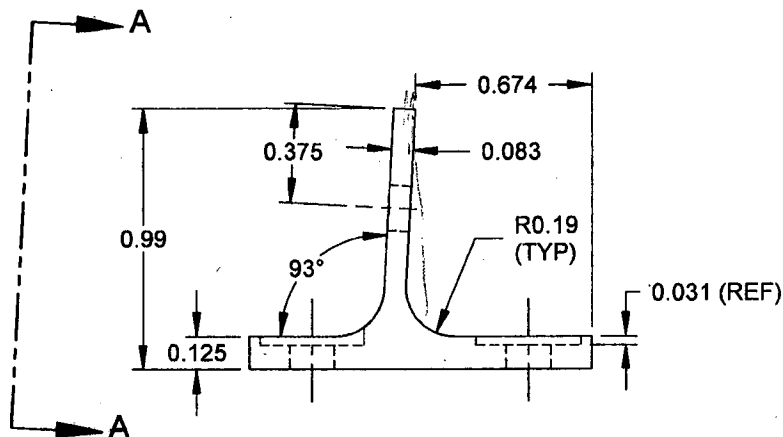
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	

**RELEASED**
06.10.13**AUXILIARY VIEW A****D3538-1 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

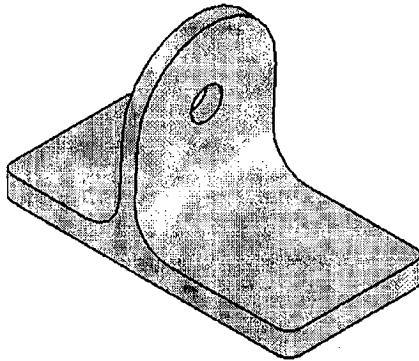
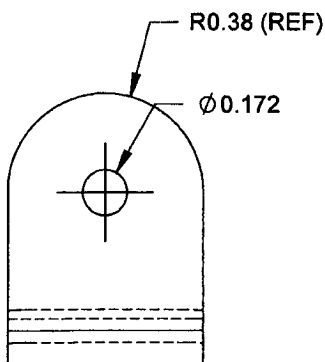
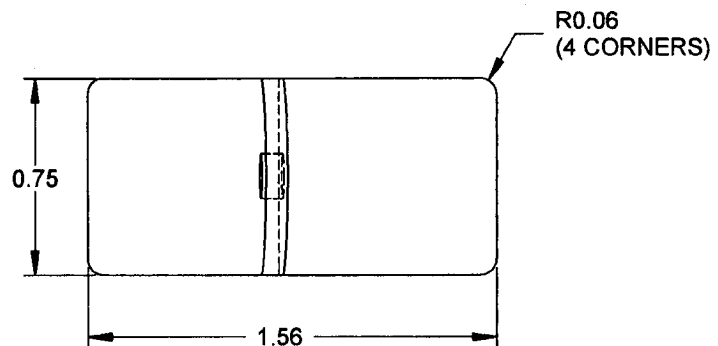
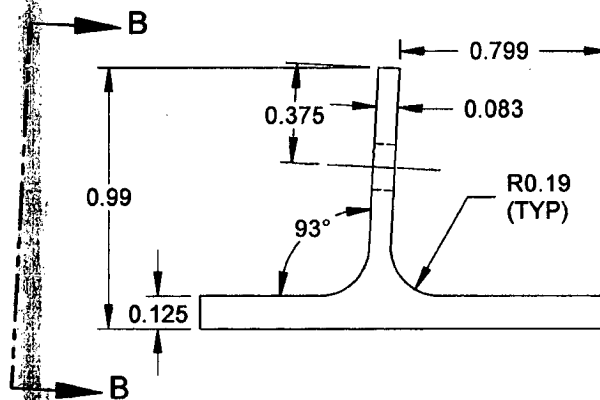
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20710109
210 30206

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13		TITLE HINGE BRACKET	SCALE 1:1

**RELEASED**
06.10.13**AUXILIARY VIEW B****D3538-3 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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c207101/09
w10 30206

DART AEROSPACE LTD		Work Order: 30206
Description:		Part Number: D35381
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.310	± .030	1.315	✓			
.750	± .030	.753	✓			
.790	± .030	.790				
.125	± 0.010	.122	✓			
.241	"	.242	✓			
.830	"	.829	✓			
.375	"	.376	✓			
.375	"	.375				
.674	"	.674				
.083	"	.081	✓			
.031	"	.029	✓			
R.190	"	.188	✓			
R.060	"	.060	✓			
Ø.172	"	.172	✓			
Ø.400x.031	"	.392x.029	✓			
93°	"	93°				
.172	"	.1725				

Measured by: J.F.
Date: 07/01/31

Audited by: SD
Date: 07.02.02

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	